

Work Order ID 57195

Monday, March 29, 2010 9:57:03 AM



HAC

Page 1

Item ID: D3910-3

Accept

Revision ID:

Item Name: Crosstube Lug

20
10.03.29

Setup Start



Start Date: 3/29/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 4/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-3-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	B								

100



Bandsaw

Memo

0.00

MW=10/03/29

20 S

Jeaspa Bandsaw

Cut to 1.450" Long

110



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: AADWG REV: B

DJP 10/03/30

20 S

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/31	110	Tool has fallen on the part during tool change and made a mark on top of the part HAAS #2	J 10/04/21	Scrap & replace Bltd# 45800	DP 10/03/31	J.P 10/03/31	J 10/04/21	J 10/05/31

NOTE: Date & initial all entries

Work Order ID 57195

Monday, March 29, 2010 9:57:03 AM



Page 2

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 3/29/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 4/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

DJP 10/03/31

20



130



QC

Quality Control

QC8- Inspect parts - second check

0.00

JL 10/04/05

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

ML 10/04/06

Memo

0.00

(20)



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57195

Monday, March 29, 2010 9:57:03 AM



Page 3

Item ID: D3910-3

Revision ID:

Item Name: Crosstube Lug

Start Date: 3/29/2010 Start Qty: 4.00



Required Date: 4/2/2010 Req'd Qty: 4.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M113170 START: 10:20 PM
 Memo Temp: 320°F 0.00
 Fin: 11:00 PM

10/04/06

x20 ✓

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 10-4-5

20

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Qty of 4 For HAC
 Memo 00102 APR

0.00

Qty of 16 For Stock.

PC 10/4/06 (20)

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 57195

Monday, March 29, 2010 9:57:03 AM



Page 4

Item ID: D3910-3

Revision ID:

Item Name: Crosstube Lug

Start Date: 3/29/2010 Start Qty: 4.00

Accept



Setup Start



Required Date: 4/2/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/04/07 HJ

Memo

0.00

MF
10-4-07
PULL ON
00708

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 29, 2010 9:57:02 AM

Page 1

Work Order ID: 57195



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 3/29/2010

Required Date: 4/2/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured		No		100	f	560.8751	0.5474			



Lug Extrusion

Warehouse Location	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT06	560.8751432	
43722	173.462806	
44529	5.7731	
45800	381.639237	

2.4167

3/10/03-30

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57195
Description: XTRB2 Lug	Part Number:	D3910-3
Inspection Dwg: D3910 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

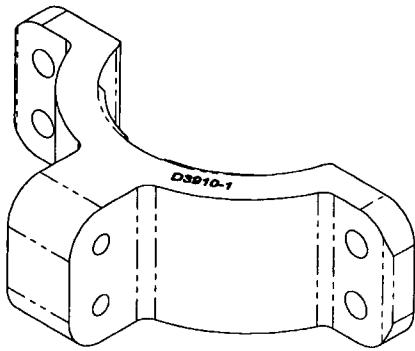
Measured by: <u>DTD</u>	Audited by: <u>SL</u>	Prototype Approval: N/A
Date: <u>10/03/01</u>	Date: <u>10/04/05</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

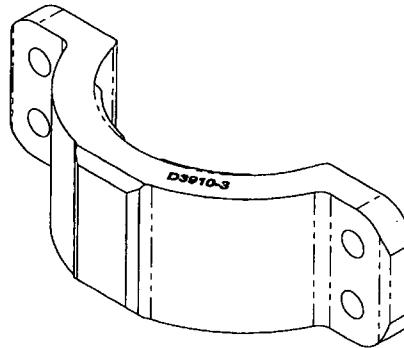
8 7 6 5 4 3 2 1

D

D



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

B

C

B

B

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

8 7 6 5 4 3 2 1

B	$\varnothing 0.257$ HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	J	D3910	SHEET 1 OF 3
APPROVED	J	TITLE	SCALE
DE APPR.	J	X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2010-03-22
MP

57195

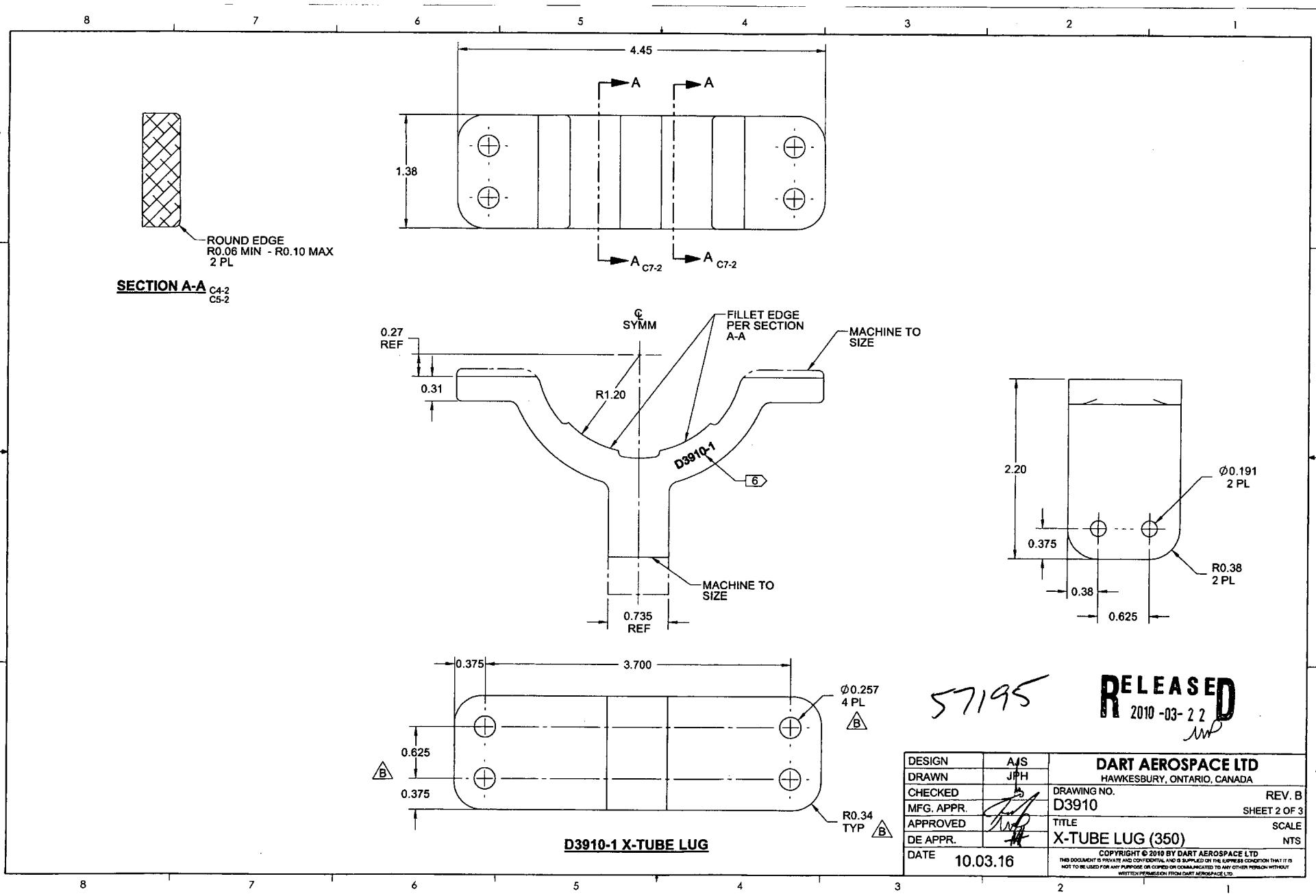
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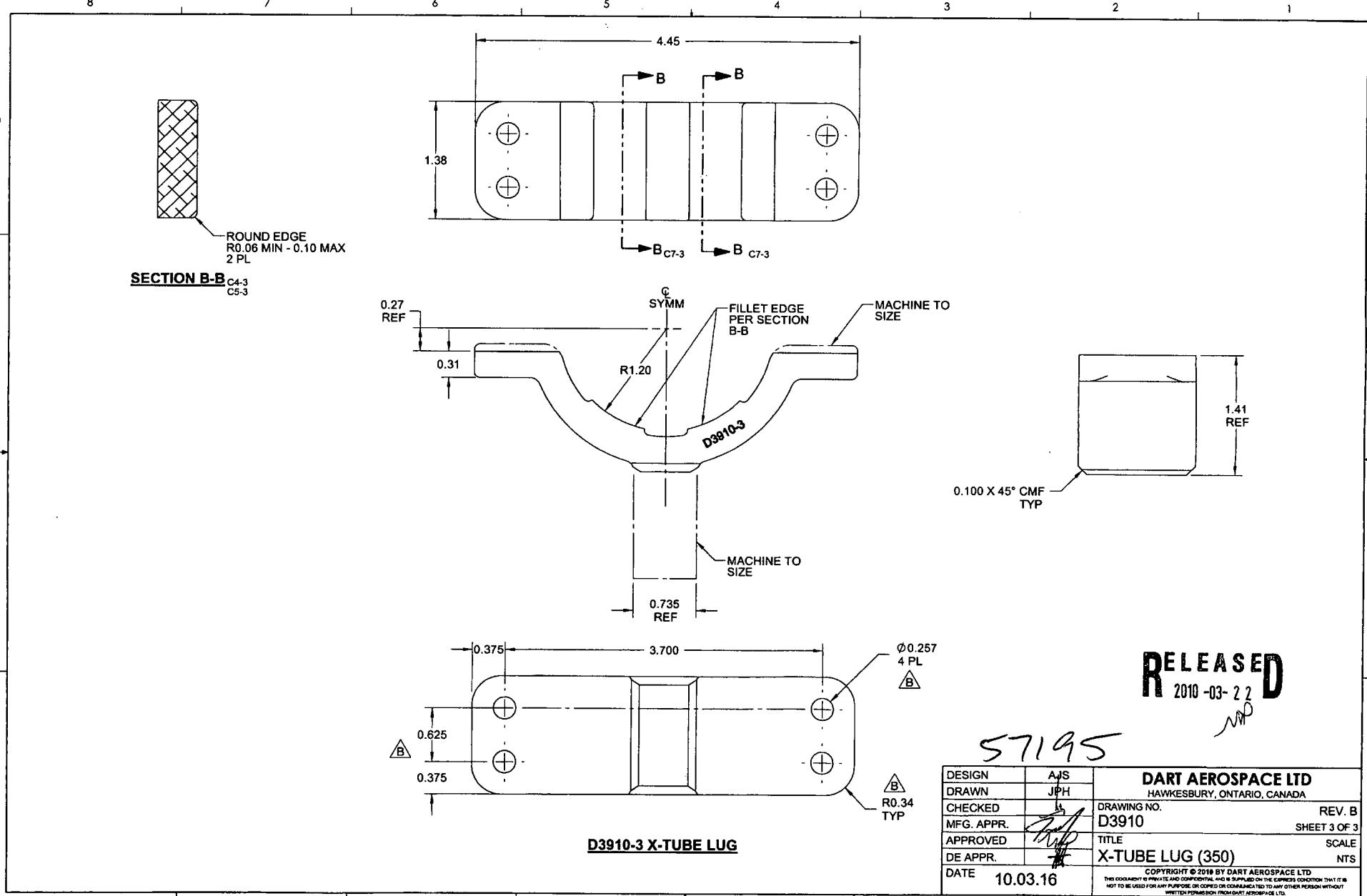


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